

Date: Wednesday, 9/26/2007 7:56:05 AM  
User: Kim Johnston

Process Sheet

SPLIT

|  |   |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SADDLE BILLET            |
| Job Number : 34874 -1                          |   |
| Estimate Number : 10034                        |   |
| P.O. Number :                                  | Part Number : D6101005                  |
| This Issue : 9/26/2007 S.O. No. :              | Drawing Number : D6101 REV A            |
| Prsht Rev. : NC                                | Project Number : N/A                    |
| First Issue : 11 Type : MACHINED PARTS         | Drawing Revision : A                    |
| Previous Run : 31388                           | Material :                              |
| Written By : <u>[Signature]</u>                | Due Date : 10/26/2007 Qty: 300 Um: Each |
| Checked & Approved By : <u>[Signature]</u>     |   |
| Comment : Est A: 01.05.04 New Issue EC         |   |

Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |    |            |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

Issue P/O: 4685

- a) Description: Alluminum billet
- b) 5.00" x 8.250" x 2.50" thick
- c) Tolerance on all dimensions are +0.030"/-0.000"
- d) Grain direction along 5.00" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

C207109126

300

|     |           |                         |
|-----|-----------|-------------------------|
| 2.0 | D6101005P | 7075-T7351 8.25X5.0X2.5 |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)  
7075-T7351 8.25X5.0X2.5

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
- Ensure material certification is attached

Pd/9

50

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

20265109 x50



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 34874

Part Number: D6101005

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CNC

SP 05/05/15

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/15

Job Completion



U 05-05-14



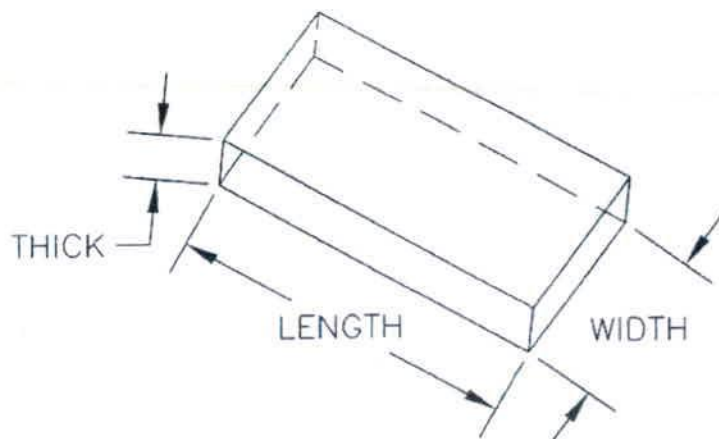




|                     |                       |   |                        |
|---------------------|-----------------------|---|------------------------|
| DESIGN<br><i>CP</i> | DRAWN BY<br><i>CP</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>A</i> | APPROVED<br><i>AS</i> | DRAWING NO.<br>D6101                              | Rev. A<br>SHEET 1 OF 1 |
| DATE<br>01.03.30    |                       | TITLE<br>SADDLE BILLET, 7075                      | SCALE<br>NTS           |
| A                   | 01.03.30              | NEW ISSUE   |                        |

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 *A*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34874

| Part No.  | Alloy                    | Length | Width | Thick | Grain Direction    |
|-----------|--------------------------|--------|-------|-------|--------------------|
| D6101-001 | 7075-T7351 (QQ-A-250/12) | 6.000  | 6.250 | 2.000 | Along 6.000 Length |
| D6101-003 | 7075-T7351 (QQ-A-250/12) | 7.875  | 6.250 | 2.000 | Along 7.875 Length |
| D6101-005 | 7075-T7351 (QQ-A-250/12) | 5.000  | 8.250 | 2.500 | Along 5.000 Length |
| D6101-007 | 7075-T7351 (QQ-A-250/12) | 7.750  | 8.250 | 2.500 | Along 7.750 Length |
| D6101-009 | 7075-T7351 (QQ-A-250/12) | 8.700  | 8.250 | 2.500 | Along 8.700 Length |
| D6101-011 | 7075-T7351 (QQ-A-250/12) | 9.700  | 8.250 | 2.500 | Along 9.700 Length |
| D6101-013 | 7075-T7351 (QQ-A-250/12) | 10.100 | 8.250 | 2.500 | Along 10.10 Length |
|           |                          |        |       |       |                    |
|           |                          |        |       |       |                    |
|           |                          |        |       |       |                    |
|           |                          |        |       |       |                    |

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## SHIP TO:

A M CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

## SOLD TO:

AM CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4119248

|                                 |                         |                           |                     |   |                     |   |  |                        |  |
|---------------------------------|-------------------------|---------------------------|---------------------|---|---------------------|---|--|------------------------|--|
| CUSTOMER PO NUMBER:<br>01-40222 |                         | WORK PACKAGE:             |                     | CUSTOMER PART NUMBER:<br>6879 A97075-60 |                     | SHIP RUN/LOAD ID:<br>101195/3             |  | GOV'T CONTRACT NUMBER: |  |
| KAISER ORDER NO:<br>1060428     | LINE ITEM:<br>1         | SHIP DATE:<br>20-JAN-2008 | ALLOY:<br>7075      | CLAD:<br>BARE                           | TEMPER:<br>T7351    | PRODUCT DESCRIPTION:<br>MILL FINISH PLATE |  |                        |  |
| WEIGHT SHIPPED:<br>7194 LB      | QUANTITY:<br>4 PCS EST. | B/L NUMBER:<br>2016136    | GAUGE:<br>2.5000 IN |   | WIDTH:<br>48.500 IN | LENGTH:<br>144.500 IN                     |  |                        |  |

### Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev06  
BSS 7055/RevA  
DPS 4.713/RevAH  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevR  
EAC MS1011/RevE  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GAMPS 9101/RevB  
PS 21211/RevK

Test Code: 4297

### Test Results

Lot: 410016A0 Cast 146

Drop 58

Ingot 4

(ASTM E8/B557)

| Tensile: | Temper | Dir / # Tests    | Ultimate KSI (MPA)         | Yield KSI (MPA)            | Elongation % |
|----------|--------|------------------|----------------------------|----------------------------|--------------|
|          | T7351  | LT / 2 (Min:Max) | 70.3 : 72.0<br>(485 : 496) | 59.3 : 61.5<br>(409 : 424) | 10.5 : 11.0  |

(ASTM E1004)

| Conductivity %IACS : | 41.6 Min | 41.7 Max |
|----------------------|----------|----------|
| (MS/M) :             | 24.1 Min | 24.2 Max |

(ASTM E1251)

| Chemistry: | SI   | FE   | CU  | MN   | MG  | CR   | ZN  | TI   | V    | ZR   | OTHER    |
|------------|------|------|-----|------|-----|------|-----|------|------|------|----------|
| Actual     | 0.09 | 0.18 | 1.5 | 0.01 | 2.4 | 0.20 | 5.6 | 0.02 | 0.01 | 0.01 | TOT 0.04 |

CASTLE METALS CORP.  
DATE RCVD 1/23/08  
IAC 6879  
APPROVED BY [Signature]





## SHIP TO:

A M CASTLE & CO  
3050 SOUTH HYDRAULIC  
WICHITA, KS 67216

## SOLD TO:

AM CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number

4119118

1AC 6879

|                                 |                         |                           |                |   |                  |   |  |                        |  |
|---------------------------------|-------------------------|---------------------------|----------------|---|------------------|---|--|------------------------|--|
| CUSTOMER PO NUMBER:<br>23-13568 |                         | WORK PACKAGE:             |                | CUSTOMER PART NUMBER:<br>6879 A97075-60 |                  | SHIP RUN/LOAD ID:<br>101194/2             |  | GOV'T CONTRACT NUMBER: |  |
| KAISER ORDER NO:<br>1060498     | LINE ITEM:<br>1         | SHIP DATE:<br>18-JAN-2008 | ALLOY:<br>7075 | CLAD:<br>BARE                           | TEMPER:<br>T7351 | PRODUCT DESCRIPTION:<br>MILL FINISH PLATE |  |                        |  |
| WEIGHT SHIPPED:<br>5436 LB      | QUANTITY:<br>3 PCS EST. | B/L NUMBER:<br>2016119    |                | GAUGE:<br>2.5000 IN                     |                  | WIDTH:<br>48.500 IN                       |  | LENGTH:<br>144.500 IN  |  |

### Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev06  
BSS 7055/RevA  
DPS 4.713/RevAH  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 026/RevR  
EAC MS1011/RevE  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GAMPS 9101/RevB  
PS 21211/RevK

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(ASTM E8/B557)

|          |        |                  |                            |                            |              |
|----------|--------|------------------|----------------------------|----------------------------|--------------|
| Tensile: | Temper | Dir / # Tests    | Ultimate KSI (MPA)         | Yield KSI (MPA)            | Elongation % |
|          | T7351  | LT / 2 (Min:Max) | 70.3 : 72.0<br>(485 : 496) | 59.3 : 61.5<br>(409 : 424) | 10.5 : 11.0  |

(ASTM E1004)

|                      |          |          |
|----------------------|----------|----------|
| Conductivity %IACS : | 41.6 Min | 41.7 Max |
| (MS/M) :             | 24.1 Min | 24.2 Max |

(ASTM E1251)

|            |      |      |     |      |     |      |     |      |      |      |          |
|------------|------|------|-----|------|-----|------|-----|------|------|------|----------|
| Chemistry: | SI   | FE   | CU  | MN   | MG  | CR   | ZN  | TI   | V    | ZR   | OTHER    |
| Actual     | 0.09 | 0.18 | 1.5 | 0.01 | 2.4 | 0.20 | 5.6 | 0.02 | 0.01 | 0.01 | TOT 0.04 |

CASTLE METALS-WIC

DATE REC'D

1-21-08

REC'D FROM

3800

APPROVED BY

4

